

Work Order ID 80415

February-21-12 9:08:15 AM

80415

Page 1

Item ID: D2662-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, RH In 206

Stop ***NS2***

Start Date: 21/02/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/02/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2662

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 & DWG

DWG REV: 1E

FOLIO REV: 44

FK 12/03/05

20 φ

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

FK 12/03/05

20 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80415

80415

Page 2

February-21-12 9:08:15 AM

Item ID: D2662-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, RH In 206

Stop ***NS2***

Start Date: 21/02/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

FK- 12/03/05

20 4

DA 12/03/06

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

OK 12/03/08

20 10

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

20 X 10 M/L 12/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80415

80415

Page 3

February-21-12 9:08:15 AM

Item ID: D2662-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, RH In 206

Stop ***NS2***

Start Date: 21/02/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat		0.00				20	2	20	12/03/12
Powder Coating	Memo								
	START TIME: 8h00 320°F OVEN TEMPERATURE:								
	8h30 FINISH TIME: 112022								
160	QC3- Inspect Part Finish	0.00							
160									
QC		0.00				20	0	20	12/03/12
Quality Control	Memo								
170	Identify as per dwg & Stock Location: 434	0.00							
170									
Packaging		0.00							
Packaging	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80415***80415***

Page 4

February-21-12 9:08:15 AM

Item ID: D2662-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH In 206

Start Date: 21/02/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



180

QC

Memo

0.00

Quality Control

12/3/12 12-03-12 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-21-12 9:08:19 AM

Page 1

Work Order ID: 80415

80415

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	83.0000	1	20			

D6101-001

**

Saddle Billet

Location	Loc Qty	Loc Code
MAT040	3	
69677	2	
76836	1	
MAT045	80	
79586	80	

20

FK 12/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80415
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.123	.122	.122	.122	.122
G	0.210	0.230		.223	.224	.223	.224	.224
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.326	1.326	1.325	1.326	1.325
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.134	1.134	1.1345	1.135	1.134
N	0.100	0.180		.135	.135	.135	.135	.135
O	0.100	0.145	.140	.140	.140	.140	.140	.140
P	0.240	0.260		.253	.251	.251	.252	.251
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.550	.550	.550	.550	.550
S	0.912	0.932		.921	.922	.922	.921	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.500	.500	.500	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		.997	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.123	.118	.118	.118	.118
AE	0.235	0.240		.236	.236	.236	.236	.236
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.110	.110	.110	.110
AH	1.565	1.585		1.573	1.572	1.5735	1.574	1.573
AI								

DART AEROSPACE LTD		Work Order:	80415
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: FK-	Date: 12/03/04
Audited by: <i>onX</i>	Date: 12/03/08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	80475
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 X	7 X	8 X	9 X	10 X
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.122	.123	.123	.122	.124
G	0.210	0.230		.223	.223	.223	.223	.223
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.325	1.326	1.325	1.325	1.325
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.1345	1.135	1.135	1.134	1.135
N	0.100	0.180		.135	.135	.135	.135	.135
O	0.100	0.145	.140	.140	.140	.140	.140	.140
P	0.240	0.260		.250	.251	.252	.252	.251
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.550	.550	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.500	.500	.500	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y'	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.118	.118	.119	.119	.118
AE	0.235	0.240		.236	.236	.236	.236	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.110	.110	.110	.110	.110
AH	1.565	1.585		1.5725	1.574	1.574	1.573	1.573
AI								

DART AEROSPACE LTD		Work Order: 8045
Description: 206 Saddle, Inboard, Right side		Part Number: D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: Fk **Date:** 12/03/04

Audited by: [Signature] **Date:** 12/03/08

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	[Signature]

DART AEROSPACE LTD		Work Order: 80415
Description: 206 Saddle, Inboard, Right side		Part Number: D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1) 1	12 2	13 3	14 4	15 5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.123	.123	.124	.124	.124
G	0.210	0.230		.223	.223	.224	.223	.223
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.326	1.326	1.326	1.326	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.135	1.135	1.135	1.1345	1.1345
N	0.100	0.180		.135	.135	.135	.135	.135
O	0.100	0.145	.140	.140	.140	.140	.140	.140
P	0.240	0.260		.251	.252	.252	.252	.252
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.551	.550	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.500	.500	.500	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.118	.119	.119	.120	.120
AE	0.235	0.240		.236	.237	.236	.236	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.110	.111	.110	.110	.111
AH	1.565	1.585		1.575	1.574	1.575	1.5735	1.572
AI								

DART AEROSPACE LTD		Work Order: 80415
Description: 206 Saddle, Inboard, Right side		Part Number: D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: FK	Date: 12/02/05 12/03/05
Audited by: <i>[Signature]</i>	Date: 12/03/08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

DART AEROSPACE LTD				Work Order: 80415	
Description: 206 Saddle, Inboard, Right side				Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#16	#17	#18	#19	#20
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.123	0.122	0.121	0.121	0.122
G	0.210	0.230		0.224	0.222	0.222	0.220	0.220
H	0.615	0.685		0.680	0.680	0.680	0.680	0.680
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.326	1.327	1.327	1.327	1.327
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
L	0.470	0.530		0.500	0.500	0.500	0.500	0.500
M	1.125	1.145		1.135	1.1345	1.134	1.134	1.134
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.140		0.140	0.140	0.140	0.140	0.139
P	0.240	0.260		0.252	0.253	0.253	0.253	0.253
Q	0.677	0.697		0.687	0.687	0.687	0.687	0.687
R	0.540	0.560		0.550	0.550	0.550	0.550	0.550
S	0.912	0.932		0.922	0.922	0.922	0.922	0.922
T	0.787	0.807		0.797	0.797	0.797	0.797	0.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.500	0.500	0.500	0.500	0.500
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.120	0.119	0.118	0.120	0.120
AE	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AF	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AG	0.100	0.120		0.111	0.111	0.111	0.111	0.111
AH	1.565	1.585		1.574	1.5735	1.573	1.574	1.573
AI								

DART AEROSPACE LTD		Work Order: 80415
Description: 206 Saddle, Inboard, Right side		Part Number: D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

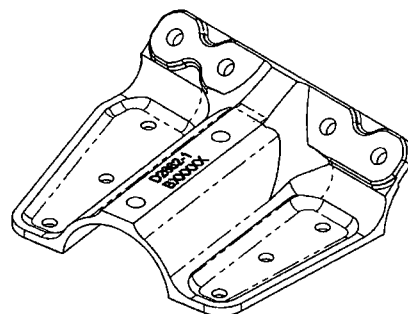
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: F.K. / B.A. 12/03/06 **Date:** 12/03/05

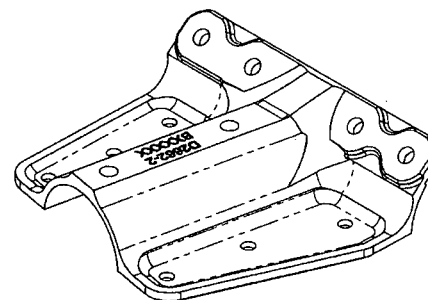
Audited by: [Signature] **Date:** 12/03/08

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

80415 H.L.S
12/02/21

RELEASED
2011-11-16
JW

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; $\Phi 0.316$ WAS $\Phi 0.313$	CB	08.11.08
C	INCORP' DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	JP		
CHECKED	ASS	DRAWING NO. D2662	REV. E SHEET 1 OF 5
MFG. APPR.	JP	TITLE SADDLE, INSIDE	SCALE NTS
DE APPR.	JP	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	11.10.31		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

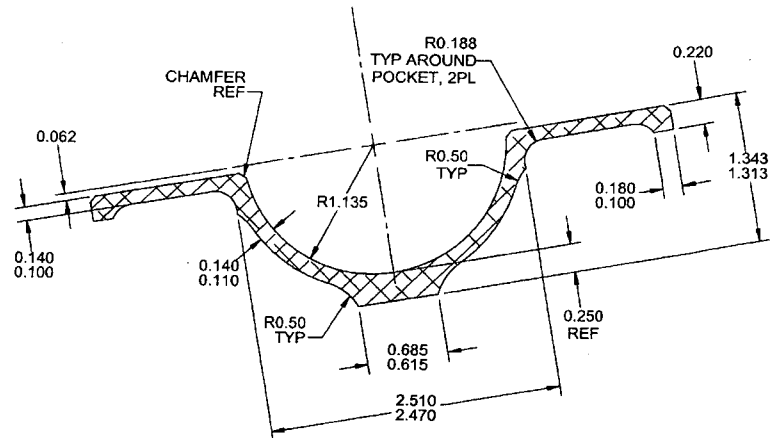
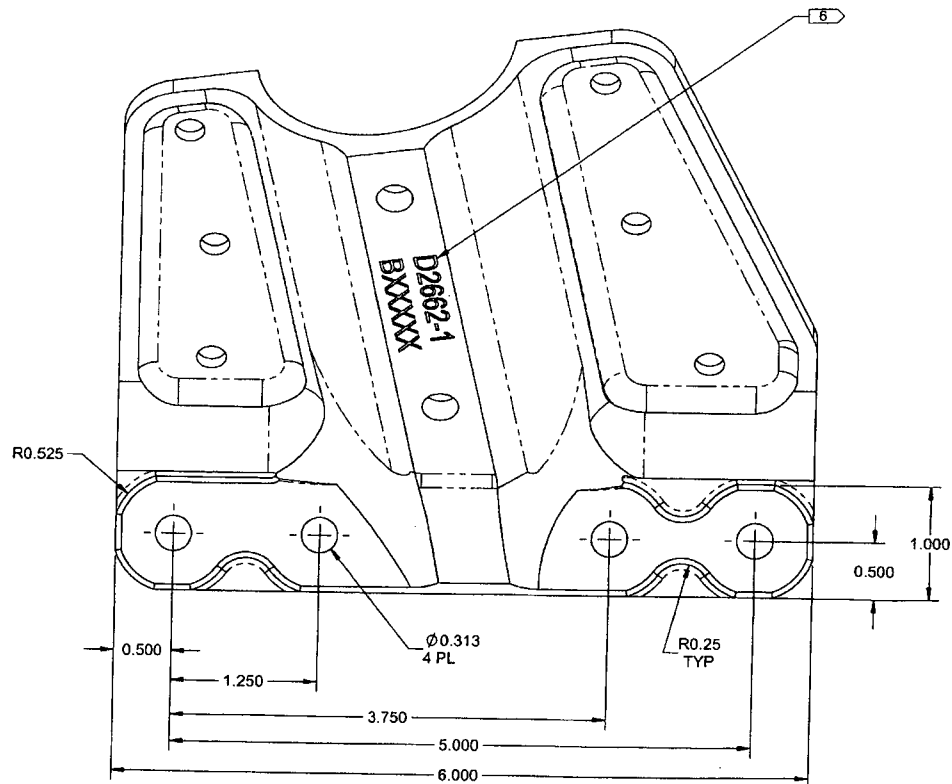
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80415



RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.
DRAWN		KENT, WA
CHECKED		DRAWING NO. D2662
MFG. APPR.		REV. E
APPROVED		SHEET 3 OF 5
DE APPR.		TITLE SADDLE, INSIDE
DATE 11.10.31		SCALE NTS

COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

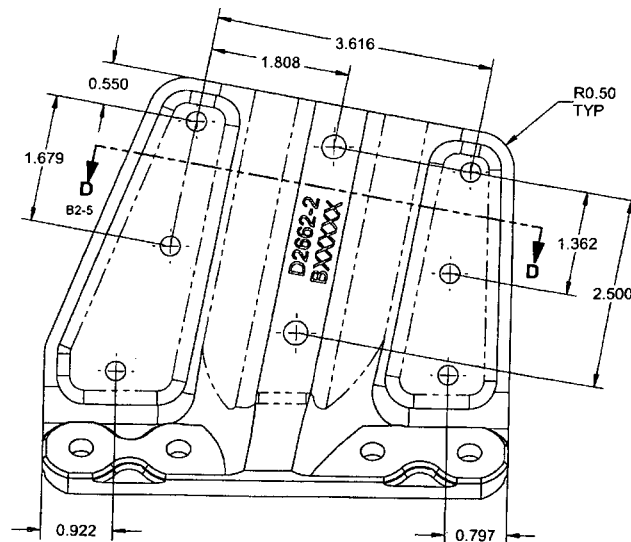
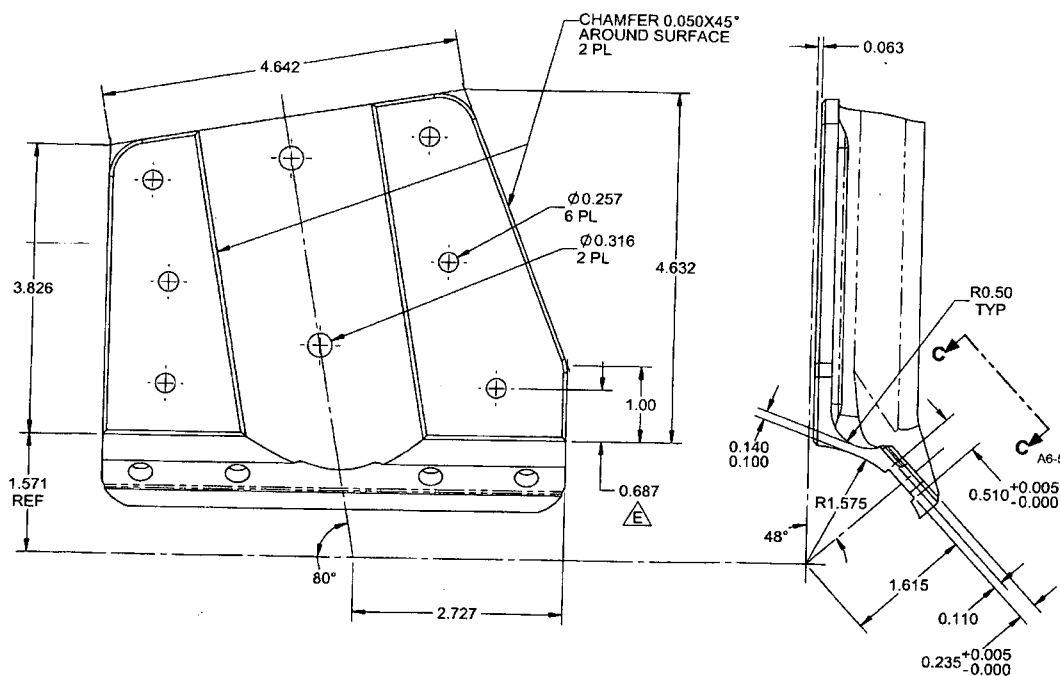
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80415



RELEASED
2011-11-16

D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

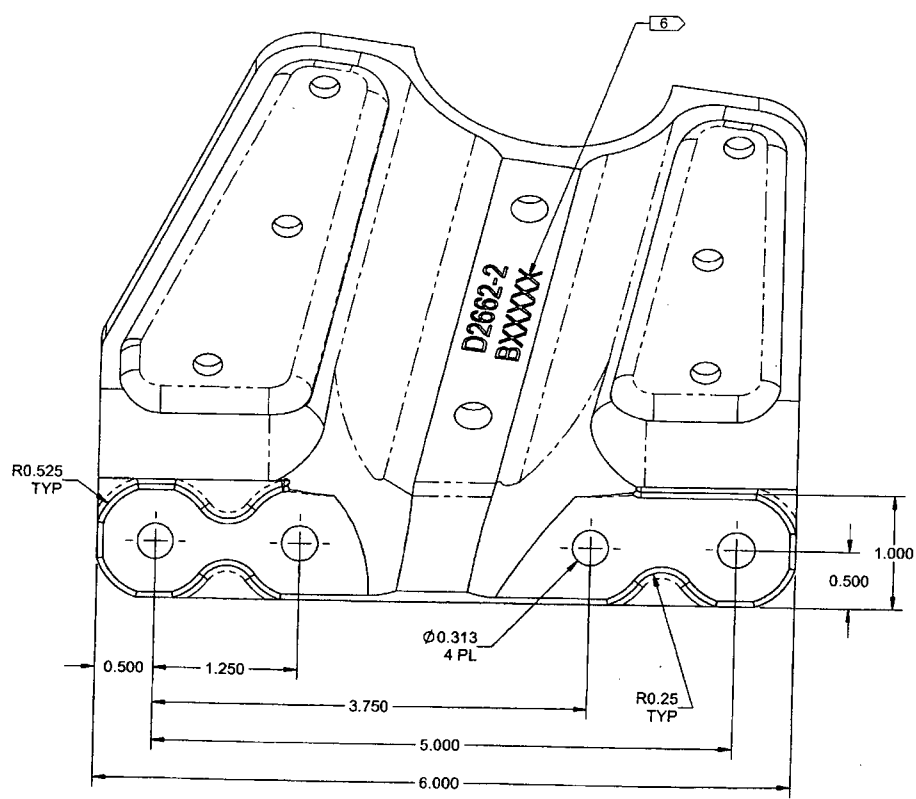
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

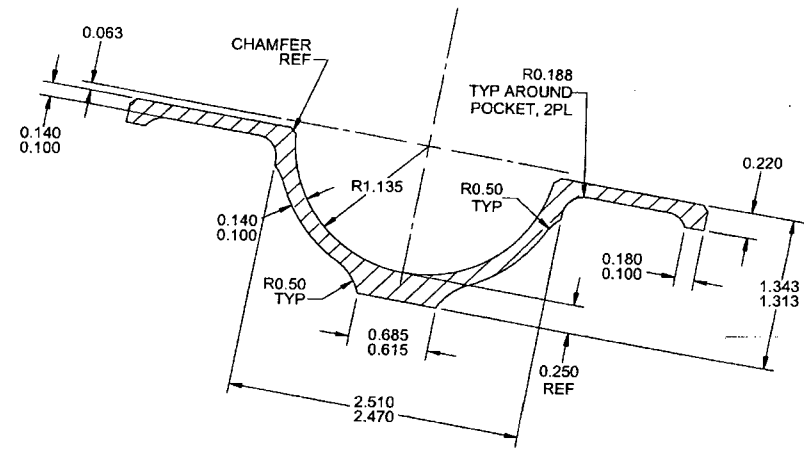
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80415



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C C3-4
SCALE 1.5X

RELEASED
2011-11-16

DESIGN	<i>JD</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>JD</i>	KENT, WA	
CHECKED	<i>JD</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JD</i>	D2662	SHEET 5 OF 5
APPROVED	<i>JD</i>	TITLE	SCALE
DE APPR.	<i>JD</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PARTY OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries